

WCR 19-7536



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5484-041

Job Sheet 188023



Part No: D5484-041

Job Qty: 18 pcs

Part Name: Aft Cap Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/18

Job Tracking No:

Created By: Jesse White

Due Date: 2/20/19

Description:

Note: IPP REV:A 17.05.26 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.03 AS PER DWG REV:A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - 1	18 pcs	2/20/19		0.00	4.50	Small Fab - 1			DAS 58 9-89 FEB 08 2019
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
110	QC 5	18 pcs	2/20/19		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 38			
							QC 5 - 42			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
QC 5 - 30										
120	Handfinish - 1-1 Chemical-B4B	18 pcs	2/20/19		0.00	0.00	Handfinish - 1 - 1 - B4B			
							Handfinish - 1 - 2 - B4B			
							Handfinish - 1 - 3 - B4B			
							Handfinish - 1 - 4 -			
Plex 12/31/18 3:16 PM dart.white.jesse										

Plex 12/31/18 3:16 PM dart.white.jesse

Yc

				B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
135 QC 7	18 pcs	2/20/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 38	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

BAG
58 FEB 11 2019
3-89

140 Small Fab - 2 - B4B	18 pcs	2/20/19	0.00 4.50	QC 7 - 50	DAS 58 9-89 FEB 11 2019
				QC 7 - 67	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
150 QC 5	18 pcs	2/20/19	0.00 0.00	Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
160 Powdercoat - 1 White GI(A)- B4B	18 pcs	2/20/19	0.00 4.50	QC 5 - 50	PD 19.02.14
				QC 5 - 30	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
170 QC 14	18 pcs	2/20/19	0.00 0.00	Powdercoat - 3 - B4B	PD 19-02-20
				Powdercoat - 4 - B4B	
				QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 38	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
180 Packaging 3-1 - Stock - B4B	18 pcs	2/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

DAS
15
9-89

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	18	2/20/19	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	70

21 FEB 20 2019

Part Op 100 - 1- Drill and C'sink rivet holes as per dwg Use DT10343 2- Deburr
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 135 - (QC7-Inspect Chemical Conversion Coat)
 140 - Install nut plates as per dwg
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), ***HAND TIGHT A SCREW IN THE NUTPLATE PRIOR TO POWDERCOAT*** START TIME: 10:15 OVEN TEMPERATURE: 320° FINISH TIME: 10:45
 170 - (QC14- Inspect Spray Paint)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-04 ST320	Nutplate Rivet	72 Ea (4 ea)	100-Small Fab - 1	5103952
D5484-1	Aft Cap	18 Ea (1 ea)	100-Small Fab - 1	3020767
MS21075L3N ST298	Nut Plate	36 Ea (2 ea)	100-Small Fab - 1	5FM137464

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	CCR264SS-3-04	72	209	0
	D5484-1	18	30	0
	MS21075L3N	36	88	0

Part Specifications

Specifications could not be found.

Plex 12/31/18 3:16 PM dart.white.jesse

Entered: TR Date: Oct 24/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7536

Route update only ☐

Job: <u>188023</u> Part No. <u>D5484-041</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date : <u>FEB 08 2019</u>		Sequence #: <u>110 QC5</u>		QTY Affected : <u>18</u>		MRB (QSI042) <u>PD</u>	
Description Work Order Deviation <u>- NUT PLATE INSTALLED PRIOR TO ALODINE.</u>				Disposition <u>- REMOVE NUT PLATE, RETURN TO OPERATION NO. 110.</u>		FEB 08 2019 Completed By <u>PD</u> FEB 08 2019 Lead hand / Supervisor <u>PD</u> FEB 08 2019 QC / QA Coordinator <u>68</u> <u>9-89</u> FEB 08 2019	
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☒ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up			
Other/Details:							